

Work Order ID 125204

Tuesday, October 07, 2014 10:38:02 AM

125204

Page 1

Item ID: D350-567-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Window Close Out
Start Date: 9/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/06/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MJS Date: 14-10-08 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| DSI 9590 | E | | | | | | | | |
| 100 | Document Control | 0.00 | | | | | | | DAS 38 9-89 |
| *100* | DOCUMENT CONTROL | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Doc.Control -USB or Paperwork | Photocopy bluefile & type labels per PPP D350-567-141 CHG003 | | | | | | | | 14-11-27 |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

NOV 11 2014

DAS
38
9-89

DAS
38
9-89

DAS
38
9-89

14-11-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 125204

125204

Page 2

Tuesday, October 07, 2014 10:38:02 AM

Item ID: D350-567-141 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Window Close Out
 Start Date: 9/24/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/06/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Packaging | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D350-567-141 | | | | | | | | |
| | Location: <u>16 033</u> | | | | | | | | |
| | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

NOV 27 2014

DAS
06
9-89

MLD 14-11-27
 MF
 14-11-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Tuesday, October 07, 2014 10:38:02 AM

Page 1

Work Order ID: 125204

125204

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B
12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05
AS PER ECN12-537 DD VERF:EC IPP REV:C 13.04.01 AS PER
DSI9590 REV.E DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| D3802-1 *D3802-1* Windows Seal (\$ Per Foot) | DAS 38 9-89 | Manufactured | No | | | 110 | f | 237.0100 | 2 | 2 | | | |
| | | | | | | | | | ** | | | | |
| | DAS 38 9-89 | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | st417 | | | | 237.01 | | | | | |
| | | | | 112283 | | | | 48 | | | | | |
| | | | | 114190 | | | | 9 | | | | | |
| | | | | 116673 | | | | 10 | | | | | |
| | | | | 117766 | | | | 0.01 | | | | | |
| | | | | 122222 | | | | 170 | | | | | |
| D4434-041 *D4434-041* Fwd Bracket Assembly | DAS 38 9-89 | Manufactured | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| | | | | | | | | | ** | | | | |
| D4435-045 *D4435-045* T/R Bellcrank Cover Assembly | DAS 38 9-89 | Manufactured | No | | | 110 | Each | 2.0000 | 1 | 1 | | | |
| | | | | | | | | | ** | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST373 | | | | 2 | | | | | |
| | | | | 114194 | | | | 2 | | | | | |
| D4435-9 *D4435-9* Bracket | DAS 38 9-89 | Manufactured | No | | | 110 | Each | 0.0000 | 2 | 2 | | | |
| | | | | | | | | | ** | | | | |
| D4436-041 *D4436-041* Aft Bracket Assembly | DAS 38 9-89 | Manufactured | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| | | | | | | | | | ** | | | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design <input type="checkbox"/> | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Handling/Pre <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Transport <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Tuesday, October 07, 2014 10:38:02 AM

Page 2

Work Order ID: 125204

125204

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

D4441-1 Manufactured No

110 f

477.0380 2 2

D4441-1

Rubber Seal

DAS
38
9-89

**

DAS
46
9-89

Location

Loc Qty

Loc Code

ST425

477.038

120932
86185

476.038
1

2

AN3-3A

Purchased No

110 Each

555.0000 7 7

AN3-3A

Bolt

DAS
38
9-89

**

DAS
46
9-89

Location

Loc Qty

Loc Code

ST350

555

m127815
m129591
m129706
m130466

3
360
1
191

7

AN525-10R6

Purchased No

110 Each

300.0000 2 2

AN525-10R6

Screw

DAS
38
9-89

**

DAS
46
9-89

Location

Loc Qty

Loc Code

ST329

300

M127743
M129390
M130005
M130325

18
100
19
163

2

NOV 11 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Tuesday, October 07, 2014 10:38:02 AM

Page 3

Work Order ID: 125204

125204

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

AN525-832R7

Purchased

No

110

Each

128.0000

2

.2

AN525-832R7

DAS
38
9-89

**

DAS
38
9-89

DAS
46
9-89

Screw

Location

Loc Qty

Loc Code

ST328

128

120560

9

m127363

19

m129909

100

MS21042L06

Purchased

No

110

Each

535.0000

7

7

MS21042L06

DAS
38
9-89

**

DAS
38
9-89

DAS
46
9-89

Nut

Location

Loc Qty

Loc Code

ST306

200

m130325

200

ST307

335

m127304

3

m128976

139

m129499

193

MS21042L08

Purchased

No

110

Each

2,818.000

2

2

MS21042L08

DAS
38
9-89

**

DAS
38
9-89

DAS
46
9-89

NOV 11 2014

Nut

Location

Loc Qty

Loc Code

ST306

2818

123900

1

125445

268

m127304

99

m127410

175

m128401

1500

m128429

69

m129541

106

m130325

600

Tuesday, October 07, 2014 10:38:02 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | |
|---|---|--|---|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions |
| <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved |
| <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | <input type="checkbox"/> Pressure/Forced |
| <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | <input type="checkbox"/> Set-up |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | <input type="checkbox"/> Temperature/Cure |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Weld |
| | | | <input type="checkbox"/> Wrong Stock Pulled |
| | | | <input type="checkbox"/> Other |

Picklist Print

Tuesday, October 07, 2014 10:38:02 AM

Page 4

Work Order ID: 125204

125204

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,862.000

5

5

MS21042L3

Nut

DAS
38
9-89

Location

Loc Qty

Loc Code

ST307

1862

123900

934

M127410

11

M127831

41

M128401

42

M128754

834

**

DAS
46
9-89

MS21059L3

Purchased

No

110

Each

261.0000

2

2

MS21059L3

Nut Plate

DAS
38
9-89

Location

Loc Qty

Loc Code

CA

17

M129682

17

ST305

244

114449

4

M127743

2

M128936

4

M129472

6

M129934

228

**

130823

DAS
46
9-89

MS35206-229

Purchased

No

110

Each

23.0000

7

7

MS35206-229

Screw

DAS
38
9-89

Location

Loc Qty

Loc Code

ST282

23

M129795

23

**

DAS
46
9-89

NOV 11 2014

DAS
46
9-89

Tuesday, October 07, 2014 10:38:02 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | |
|---|---|--|---|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions |
| <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved |
| <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | <input type="checkbox"/> Pressure/Forced |
| <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | <input type="checkbox"/> Set-up |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | <input type="checkbox"/> Temperature/Cure |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Weld |
| | | | <input type="checkbox"/> Wrong Stock Pulled |
| | | | <input type="checkbox"/> Other |

Picklist Print

Tuesday, October 07, 2014 10:38:02 AM

Work Order ID: 125204

125204

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 9/24/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

110

Each

3,863.000

12

12

NAS1149F0332P

Washer

DAS
38
9-89

Location

Loc Qty

Loc Code

ST275

3863

122063

205

123900

10

125646

106

m127831

1542

m130325

2000

**

DAS
06
9-89



NAS1149FN616P

Purchased

No

110

Each

54.0000

14

14

NAS1149FN616P

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

ST275

54

M127703

54

110

Each

552.0000

2

2

**

DAS
06
9-89



NAS1149FN816P

Purchased

No

NAS1149FN816P

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

ST275

552

117316

552

**

DAS
06
9-89



DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

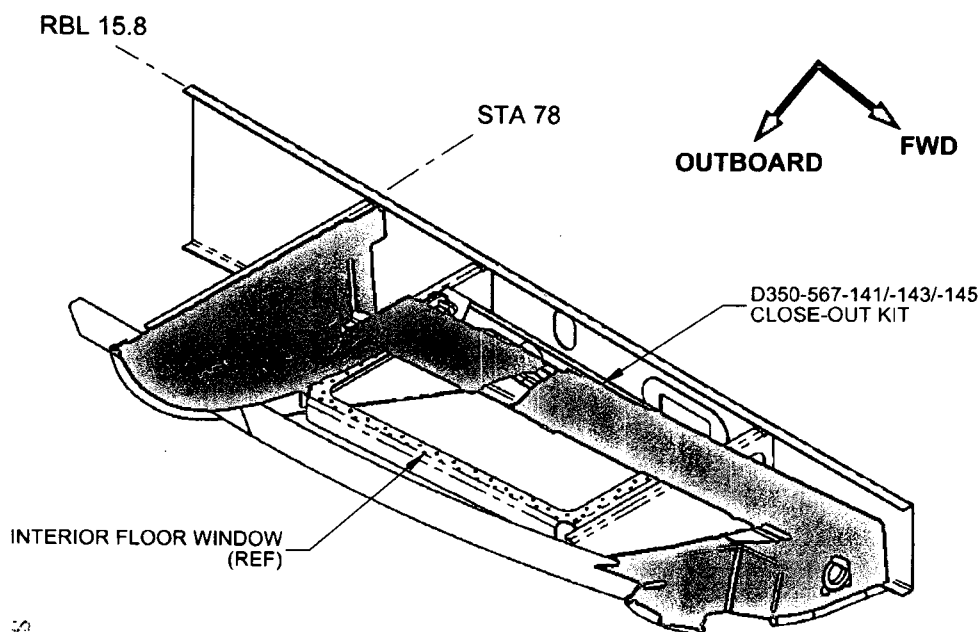


Figure 1. Floor Window Close-out Kit Installation

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125204ML5
14-10-08

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--|--|---------------|
| E | ADD -143/-145 KITS | RF | 14.03.20 |
| D | CLARIFY FIGURES 3-12 | VS | 13.09.11 |
| C | CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P | RF | 12.03.13 |
| B | MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08 | RF | 12.02.22 |
| A | NEW ISSUE | RF | 12.01.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 1 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

2.0 Parts List

| Qty -141 | Qty -143 | Qty -145 | Part Number | Description |
|-------------|-------------|-------------|---------------|---|
| X | | | D350-567-141 | FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS) |
| | X | | D350-567-143 | FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS) |
| | | X | D350-567-145 | FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e) |
| 1 | 1 | 1 | D3802-1-024 | SEAL (24") |
| 1 | 1 | | D4434-041 | FWD BRACKET ASSEMBLY |
| | 1 | | D4434-047 | COVER ASSEMBLY |
| 1 | | | D4435-045 | T/R BELLCRANK COVER ASSEMBLY |
| 2 | 2 | 2 | D4435-9 | BRACKET |
| 1 | 1 | 1 | D4436-041 | AFT BRACKET ASSEMBLY |
| 1 | 1 | 1 | D4441-1-240 | RUBBER SEAL (24") |
| | | 1 | D4730-020-030 | VELCRO STRIP |
| | 1 | 1 | D4971-041 | T/R BELLCRANK COVER ASSEMBLY |
| | | 1 | D5076-041 | FWD BRACKET ASSEMBLY |
| 7 | 5 | 5 | AN3-3A | BOLT |
| 2 | 2 | 2 | AN525-10R6 | SCREW |
| 2 | 2 | 2 | AN525-832R7 | SCREW |
| | | 1 | CB 200 | 3.5g ACRYLIC ADHESIVE |
| 7 | 7 | 7 | MS21042L06 | NUT (OR MS21042-06) |
| 2 | 2 | 2 | MS21042L08 | NUT (OR MS21042-08) |
| 5 | 5 | 5 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | 2 | 2 | MS21059L3 | NUTPLATE |
| 7 | 7 | 7 | MS35206-229 | SCREW |
| 12 | 10 | 10 | NAS1149F0332P | WASHER (AN960-10L) |
| 14 | 14 | 14 | NAS1149FN616P | WASHER (OR AN960-6L) |
| 2 | 2 | 2 | NAS1149FN816P | WASHER (OR AN960-8L) |

E

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|----------------------------|---------|---------|------------|--------------|-------------|
| | | Arm | Moment | Arm | Moment |
| D350-567-141/-143/-145 | 3.9 lb | 17.9 in | 69.8 in-lb | 65.5 in | 255.5 in-lb |
| Floor Window Close-out Kit | 1.77 kg | 0.45 m | 0.80 m-kG | 1.66 m | 2.94 m-kG |

4.0 Installation Procedure

Notes:



- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|---|--|---------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 2 OF 19 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

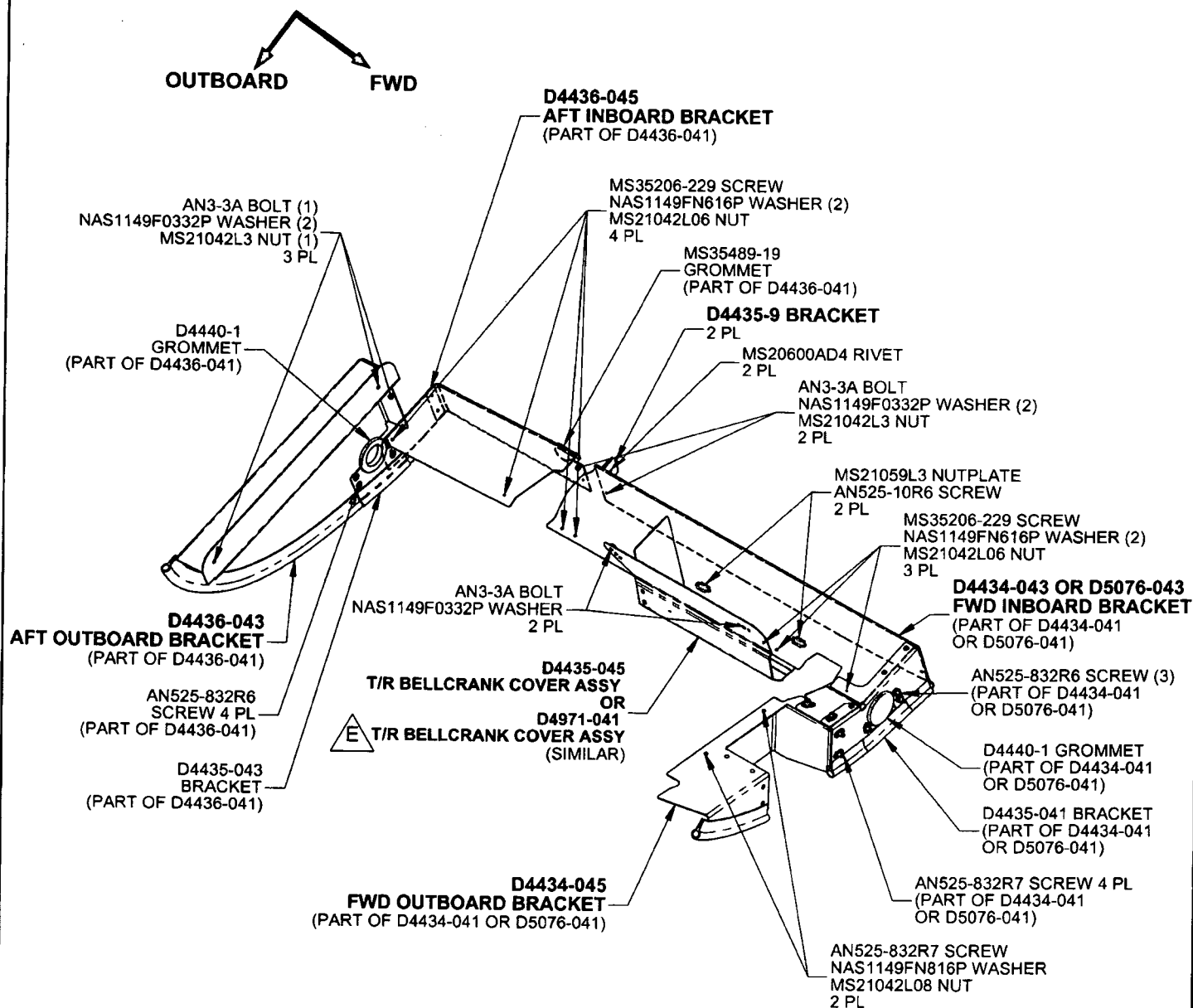


Figure 2. Floor Window Close-out Kit Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|---------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 3 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 /D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

4.3 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

E 4.4 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.6 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.7 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.8 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.9 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

E 4.10 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

E 4.11 FOR D350-567-143/-145 KIT

a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.

b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.




c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|---------------|---|--|---------------|
| DESIGN | DB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 4 OF 19 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE 14.03.20 | | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |




- d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
- e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.12 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.13 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.14 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.15 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|---------------|---|--|---------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 5 OF 19 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE 14.03.20 | | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

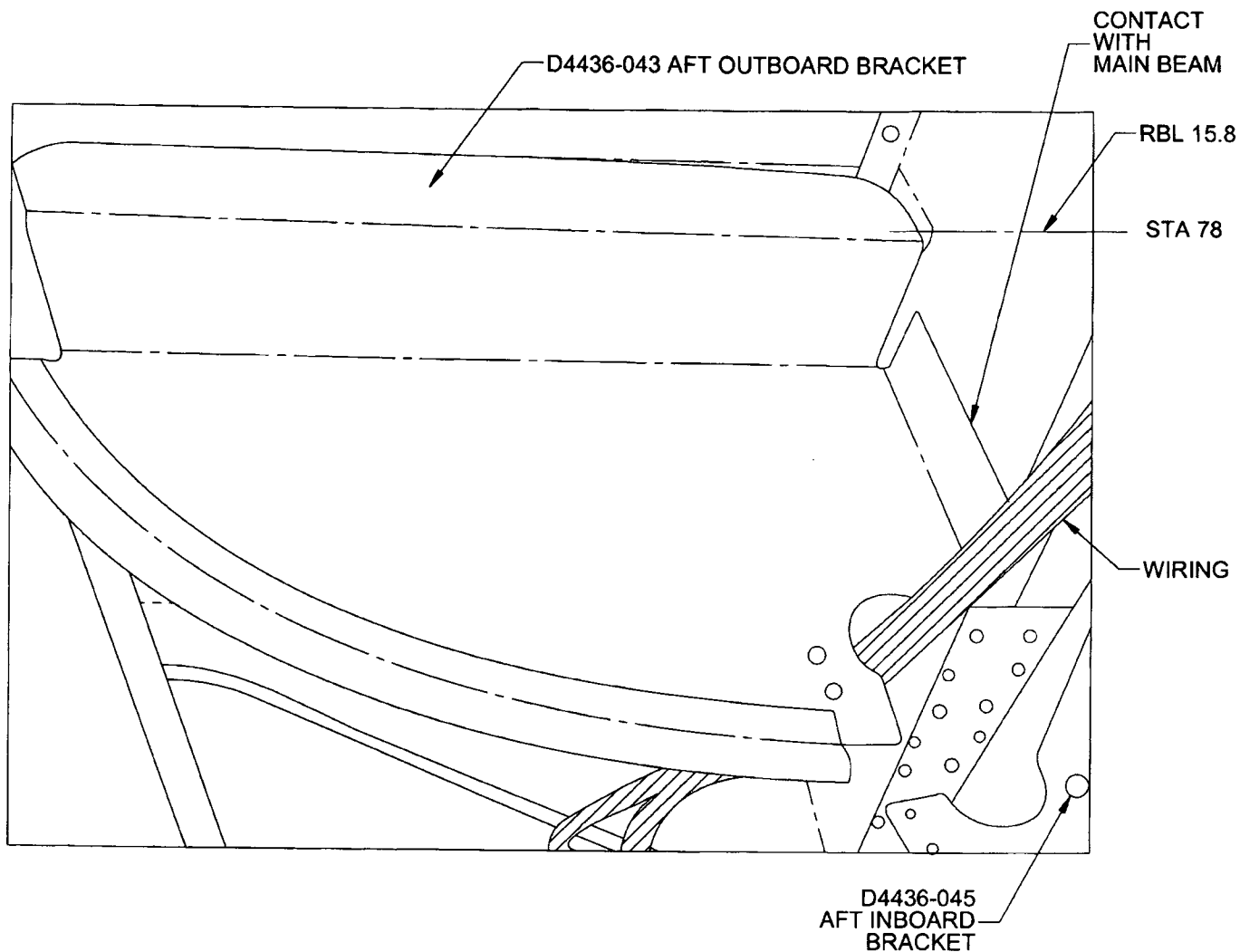


Figure 3. D4436-043 Aft Outboard Bracket Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|---------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 6 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

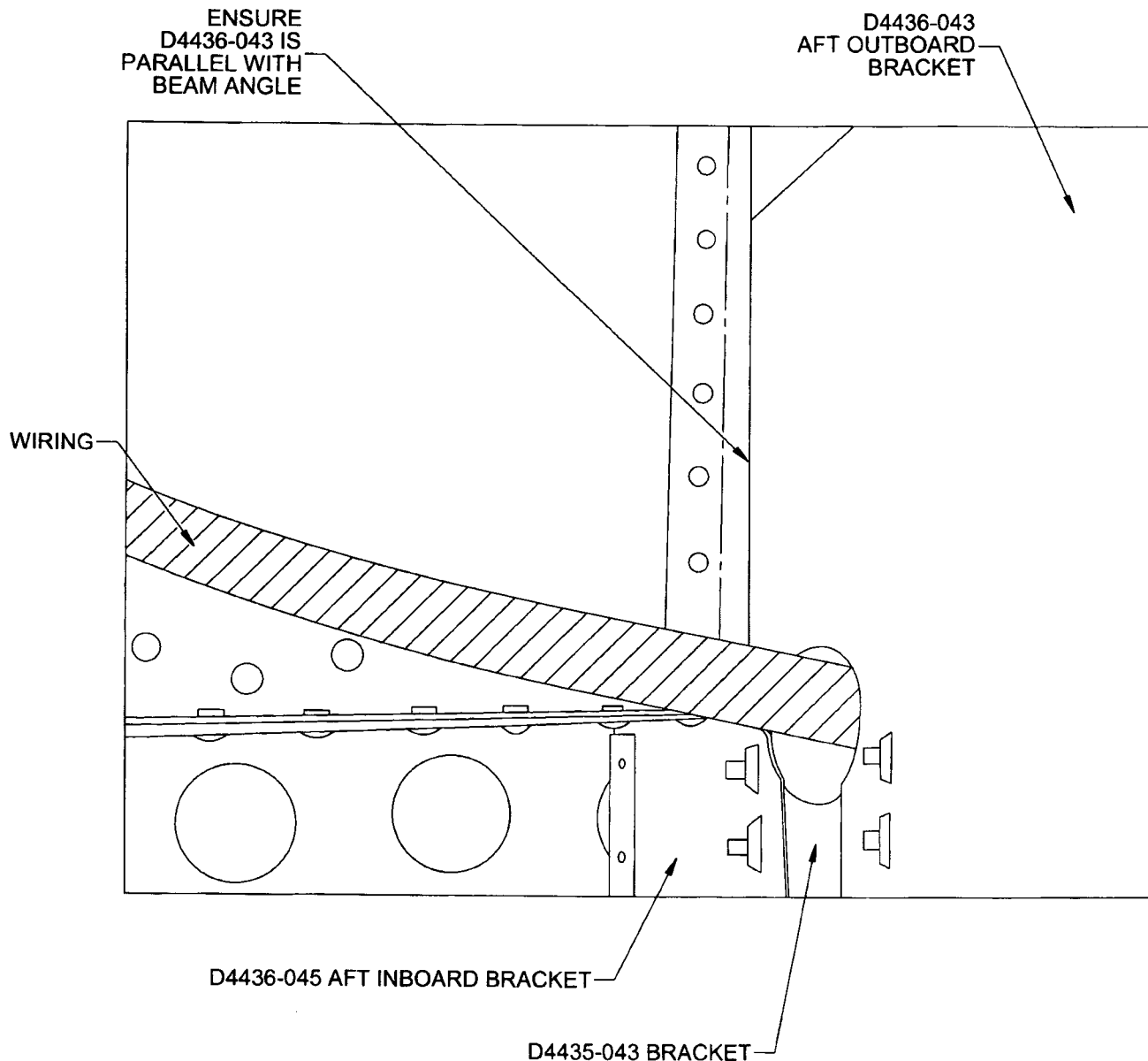


Figure 4. D4436-043 & D4435-043 Brackets Installation

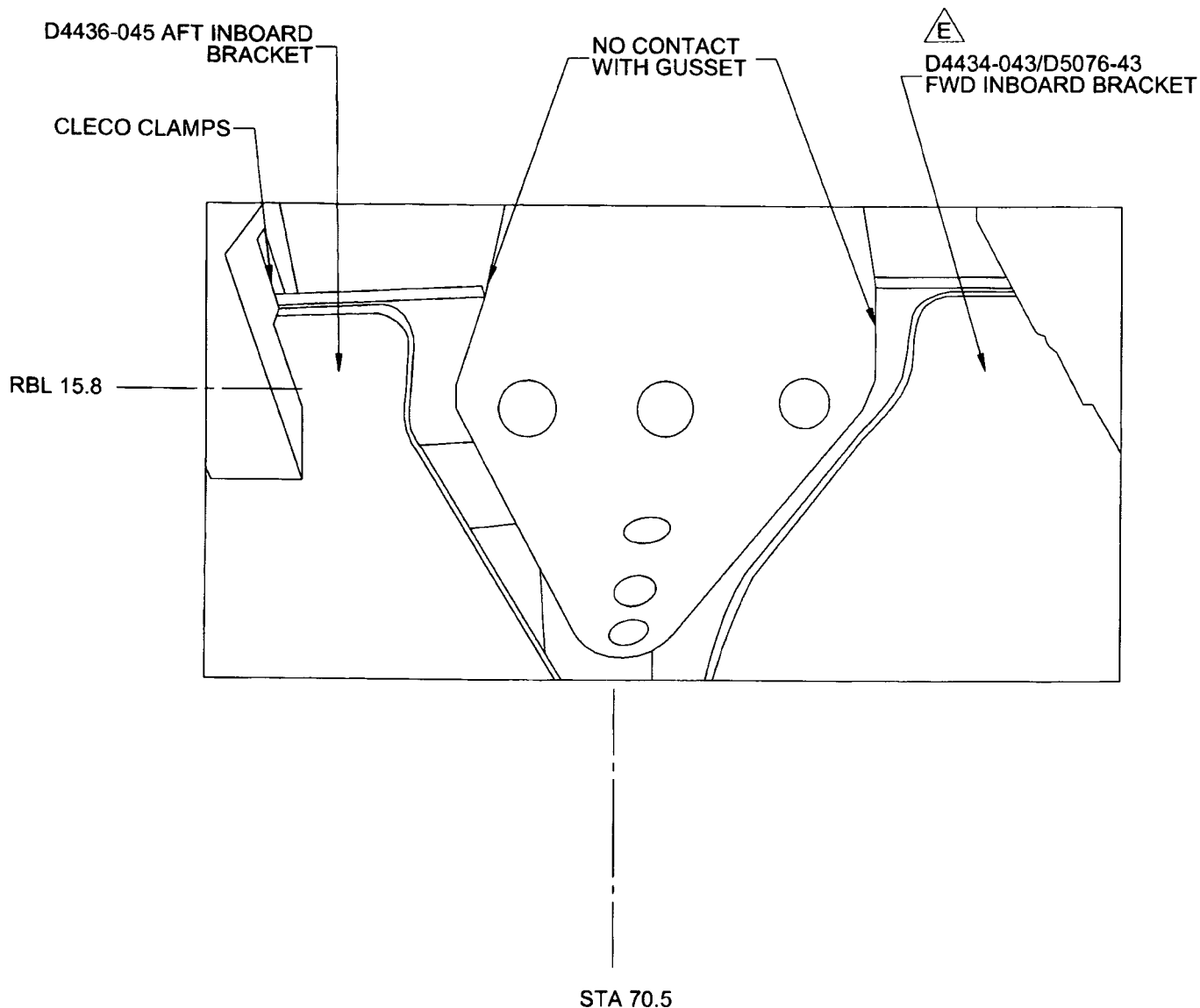
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|---|---------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <u>[Signature]</u> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 7 OF 19 |
| APPROVED | <u>[Signature]</u> | TITLE | SCALE |
| DE APPR. | <u>[Signature]</u> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



△ Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|---|--------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <u>[Signature]</u> | DRAWING NO. DSI 9590 | REV. E |
| MFG. APPR. | N/A | SHEET 8 OF 19 | |
| APPROVED | <u>[Signature]</u> | TITLE | SCALE |
| DE APPR. | <u>[Signature]</u> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

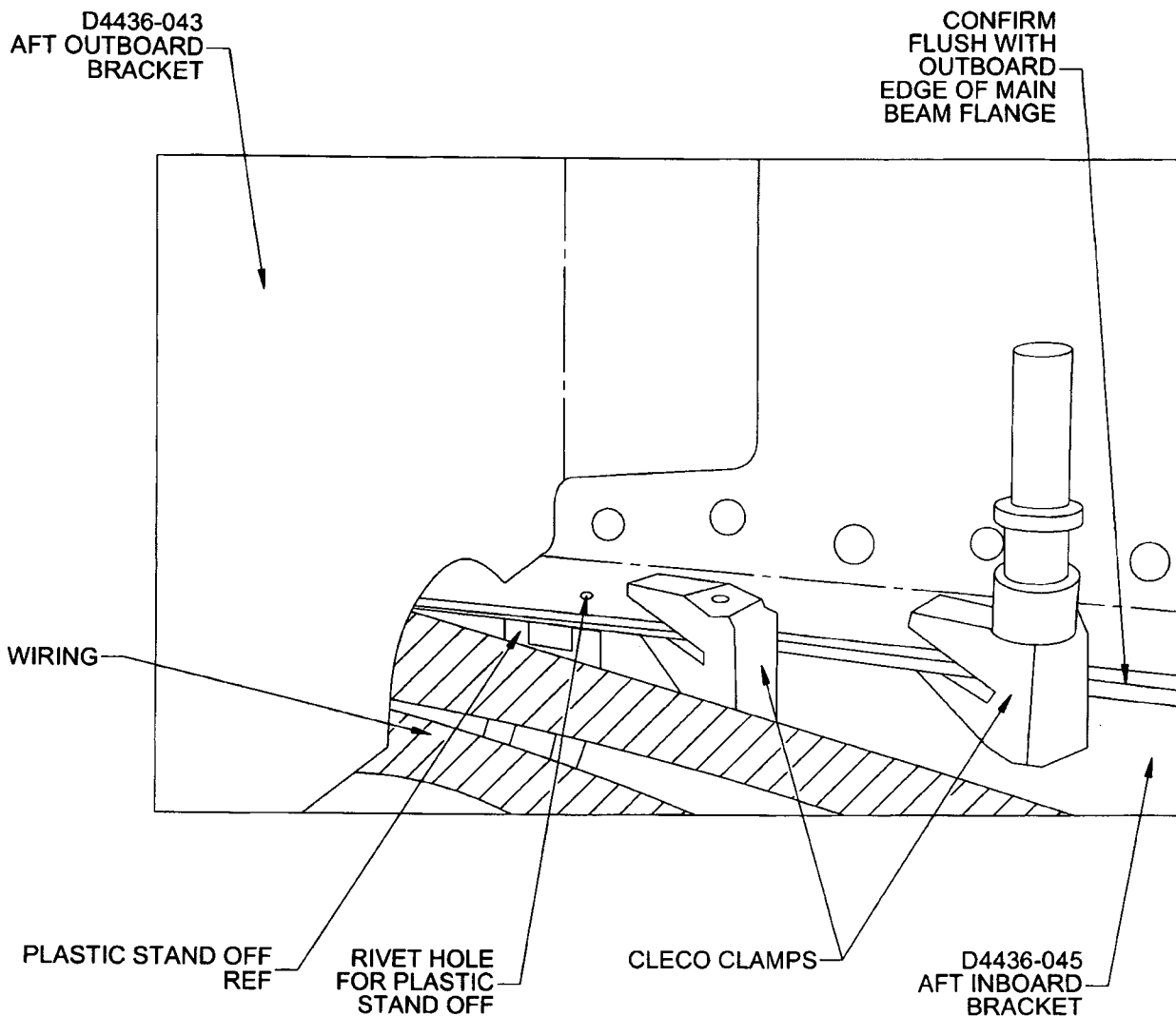


Figure 6. D4436-043 & D4436-045 Brackets Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|---------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 9 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

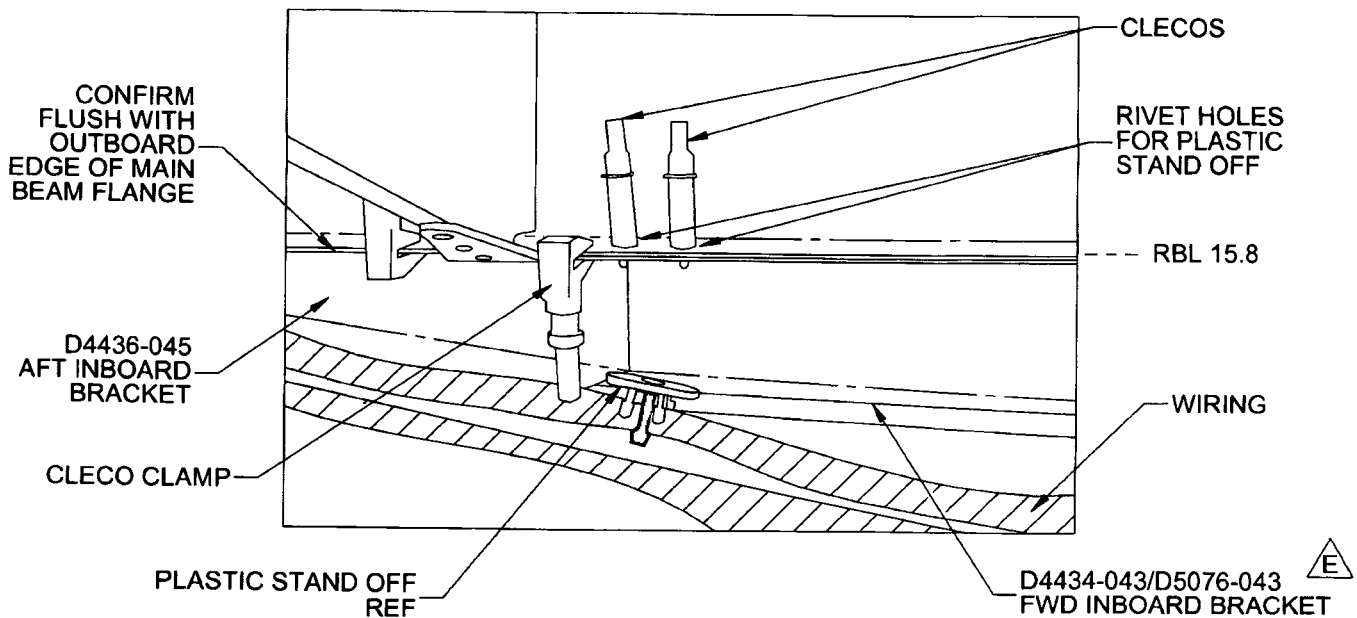


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

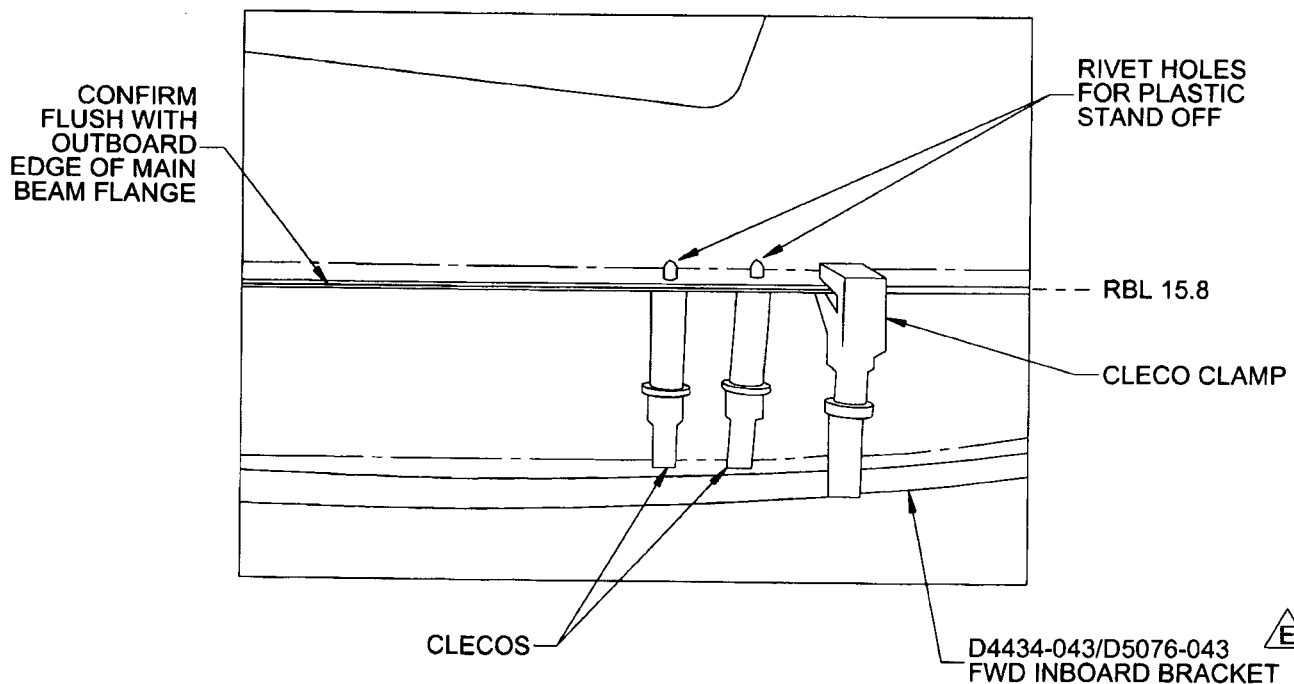


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation E

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 10 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

INSTALL
D4436-043
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

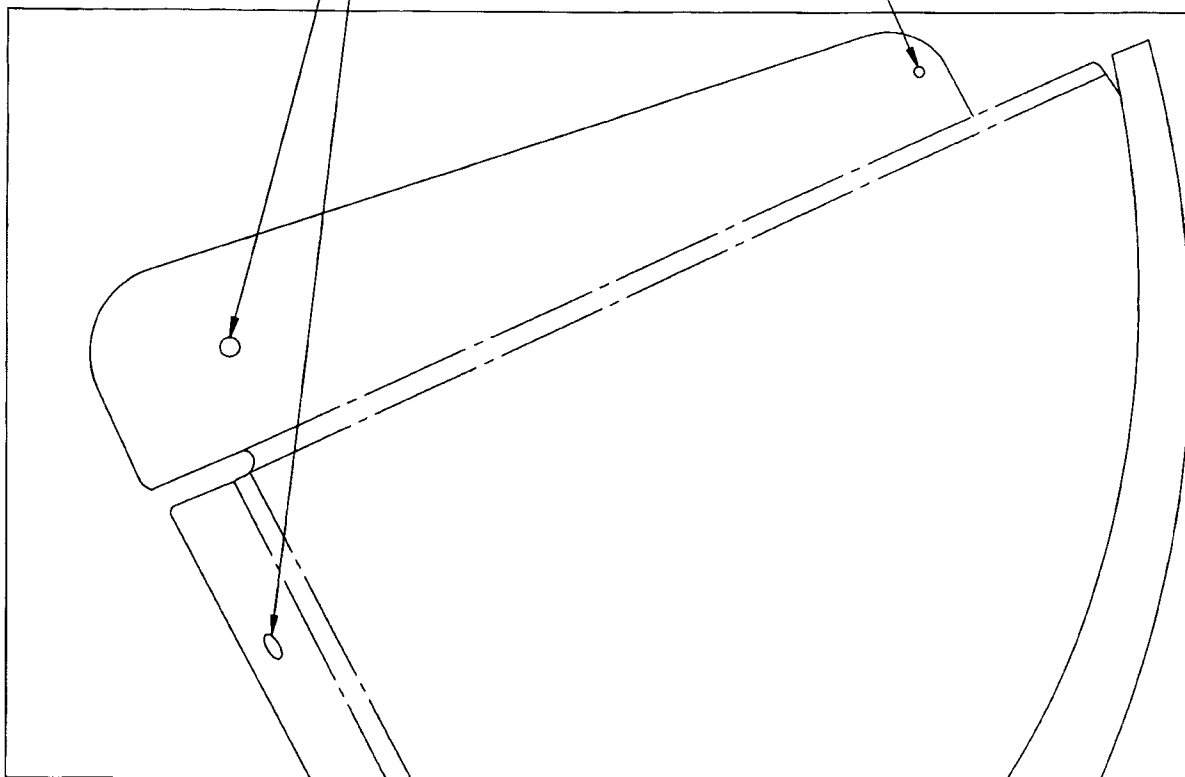


Figure 9. D4436-043 Aft Outboard Bracket Installation

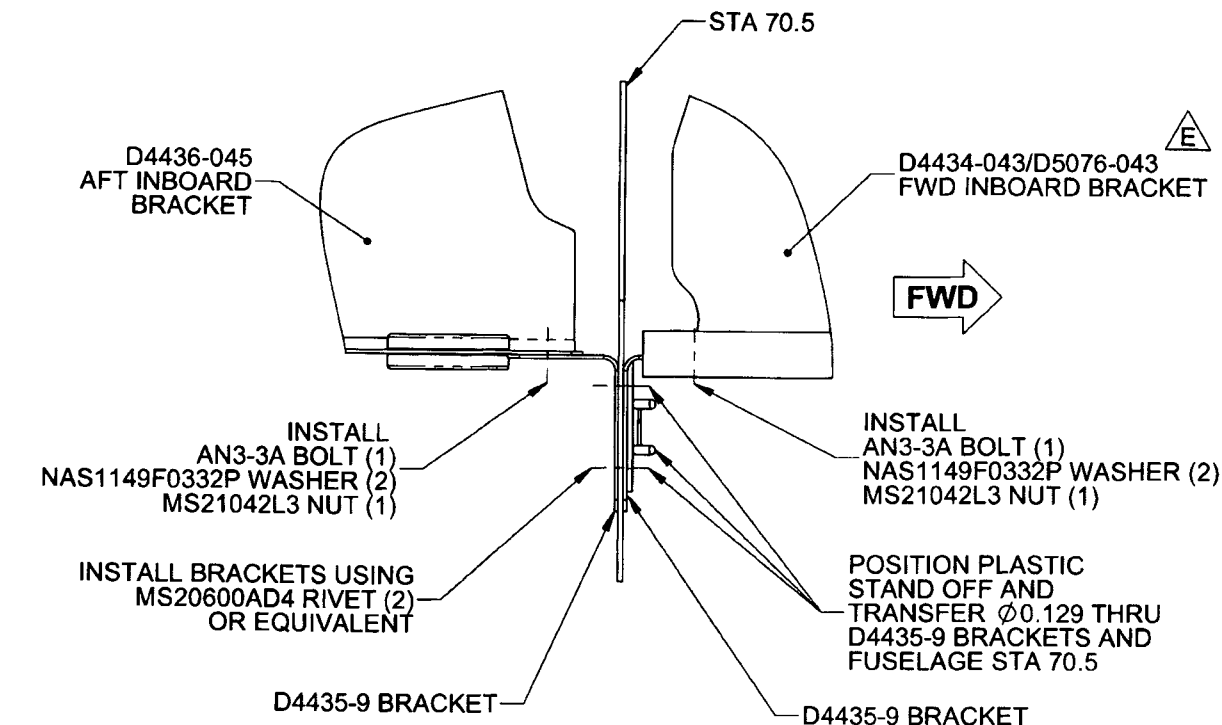
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 11 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



LOOKING UP AT STA 70.5

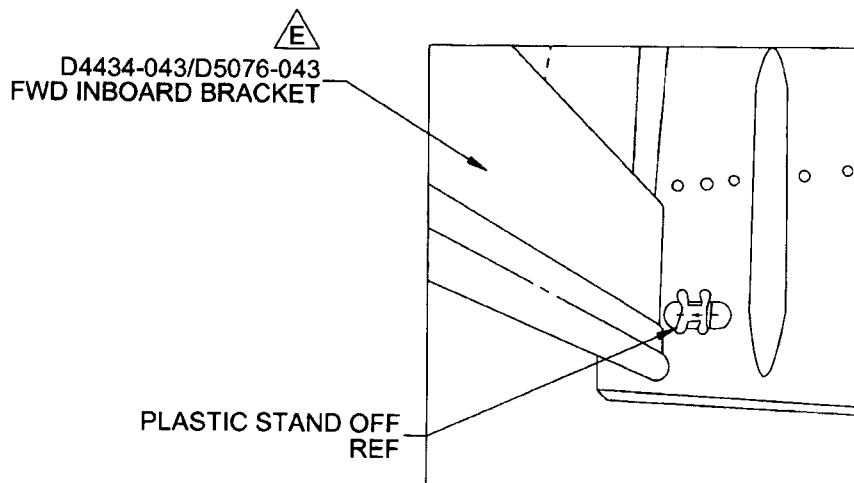





Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|---|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 12 OF 19 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

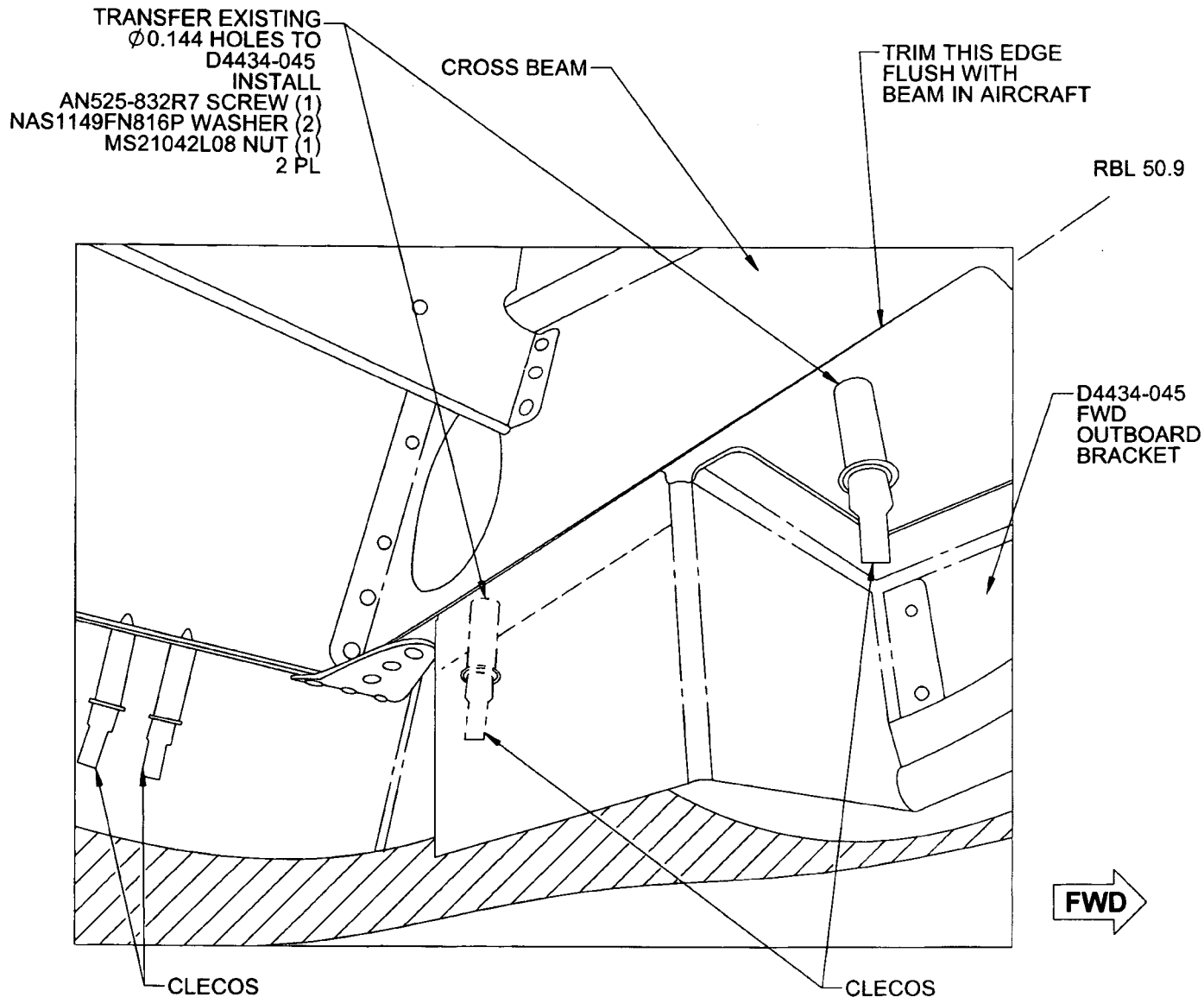


Figure 11. D4434-045 Bracket Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|--------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. DSI 9590 | REV. E |
| MFG. APPR. | N/A | SHEET 13 OF 19 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

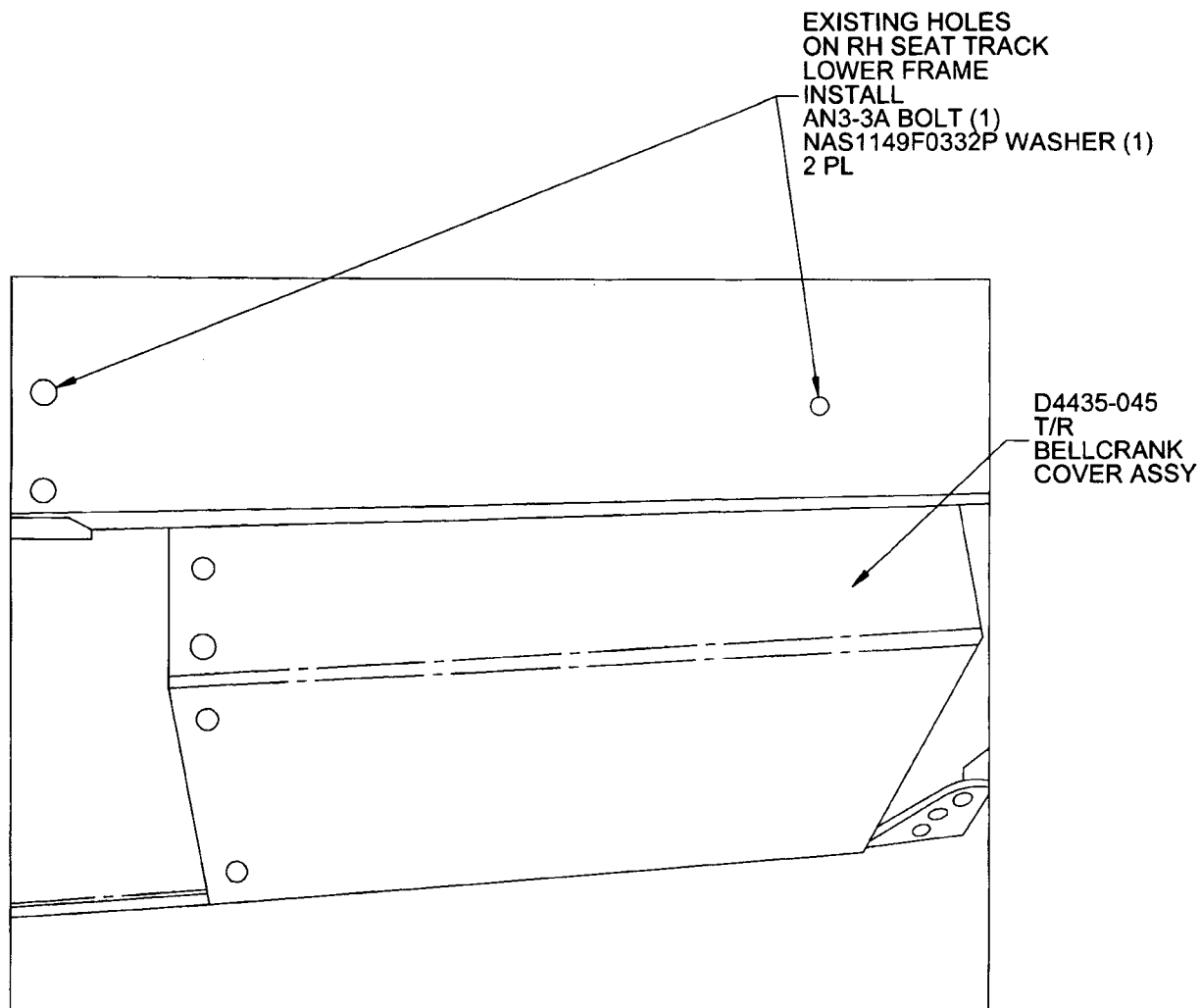


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

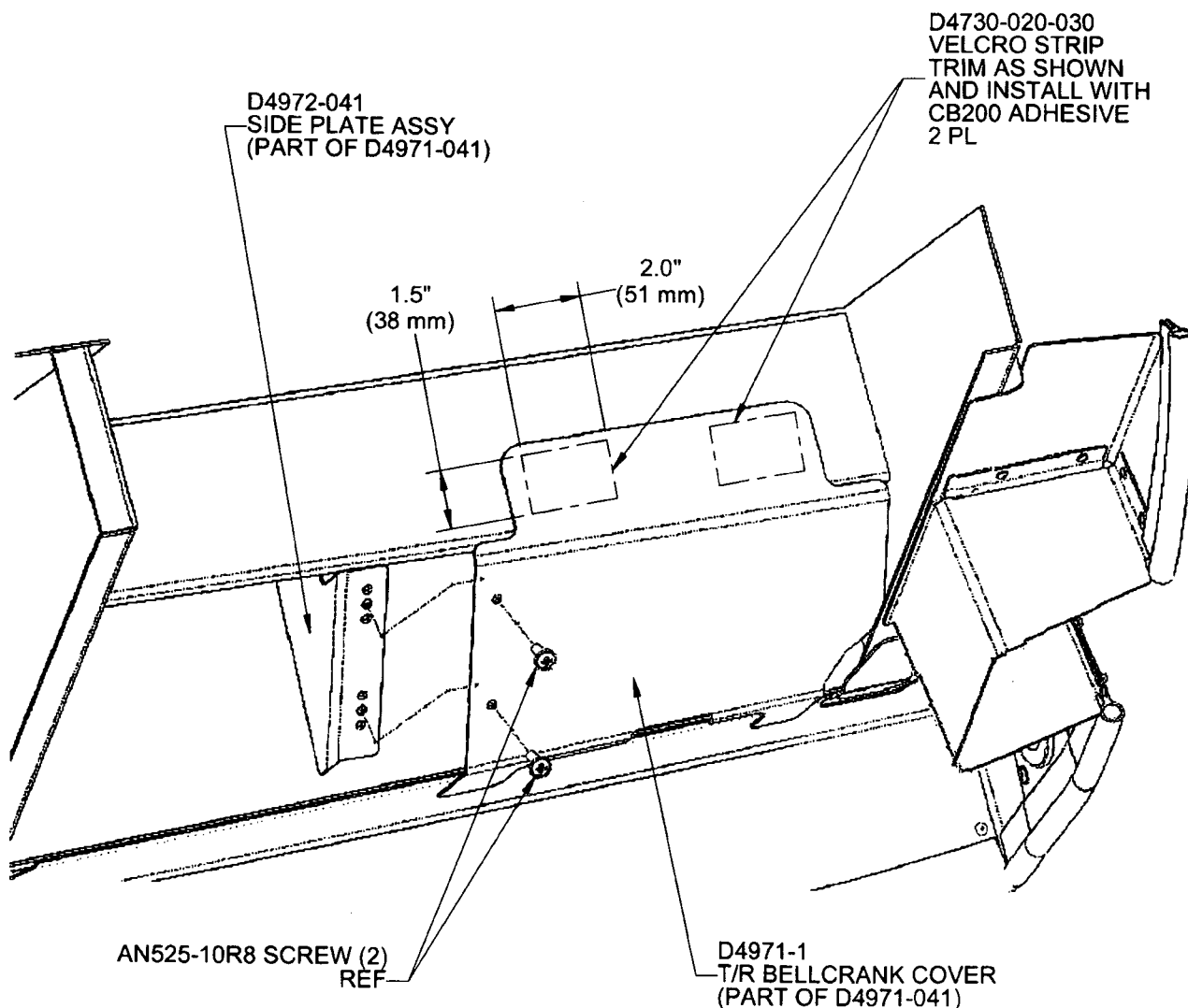
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 14 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



E Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

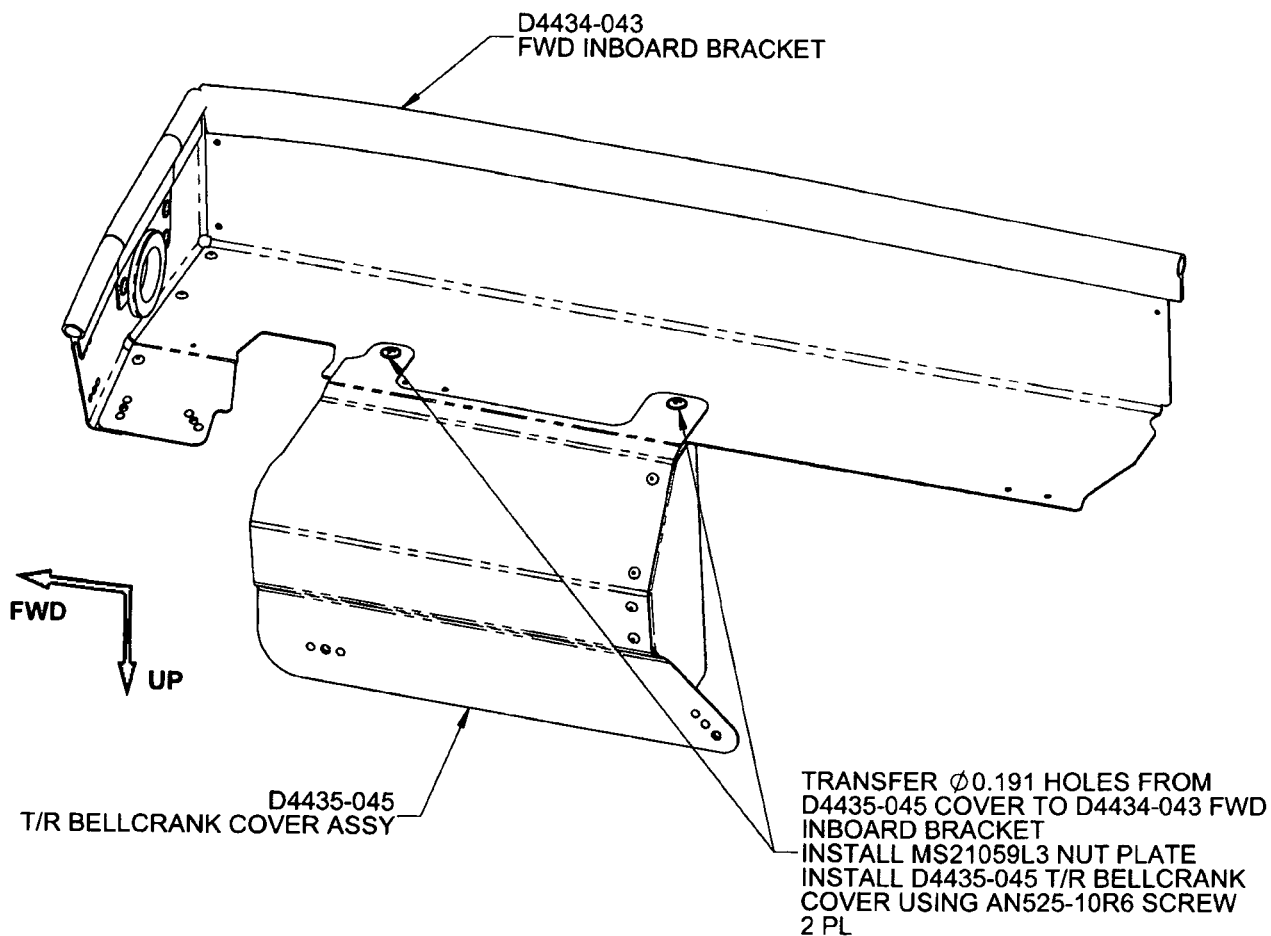
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|---|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 15 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



E Figure 13a. D4435-045 Cover Installation (-141 ONLY)

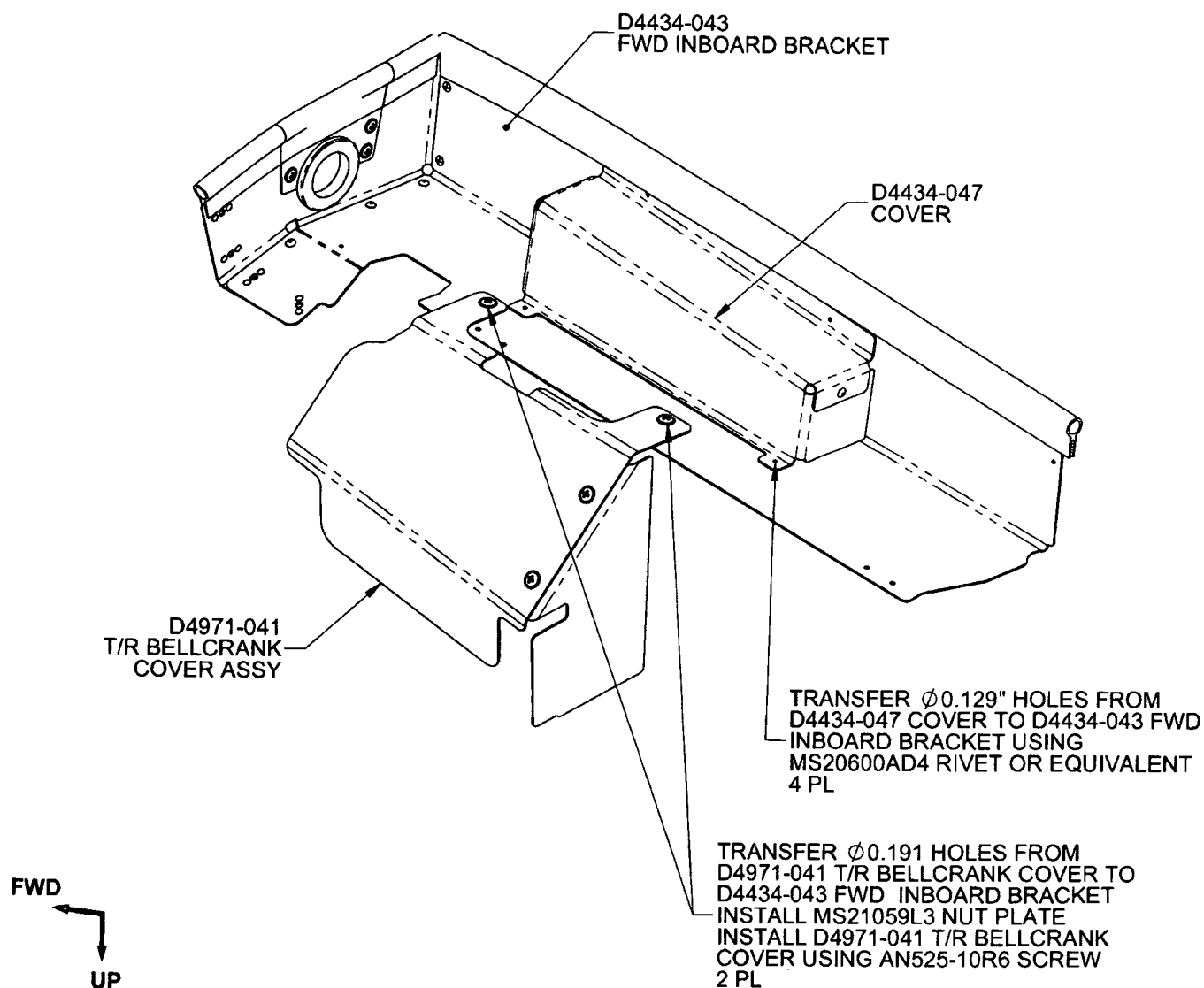
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 16 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



E Figure 13b. D4971-041 & D4434-047 Cover Installation (-143 ONLY)

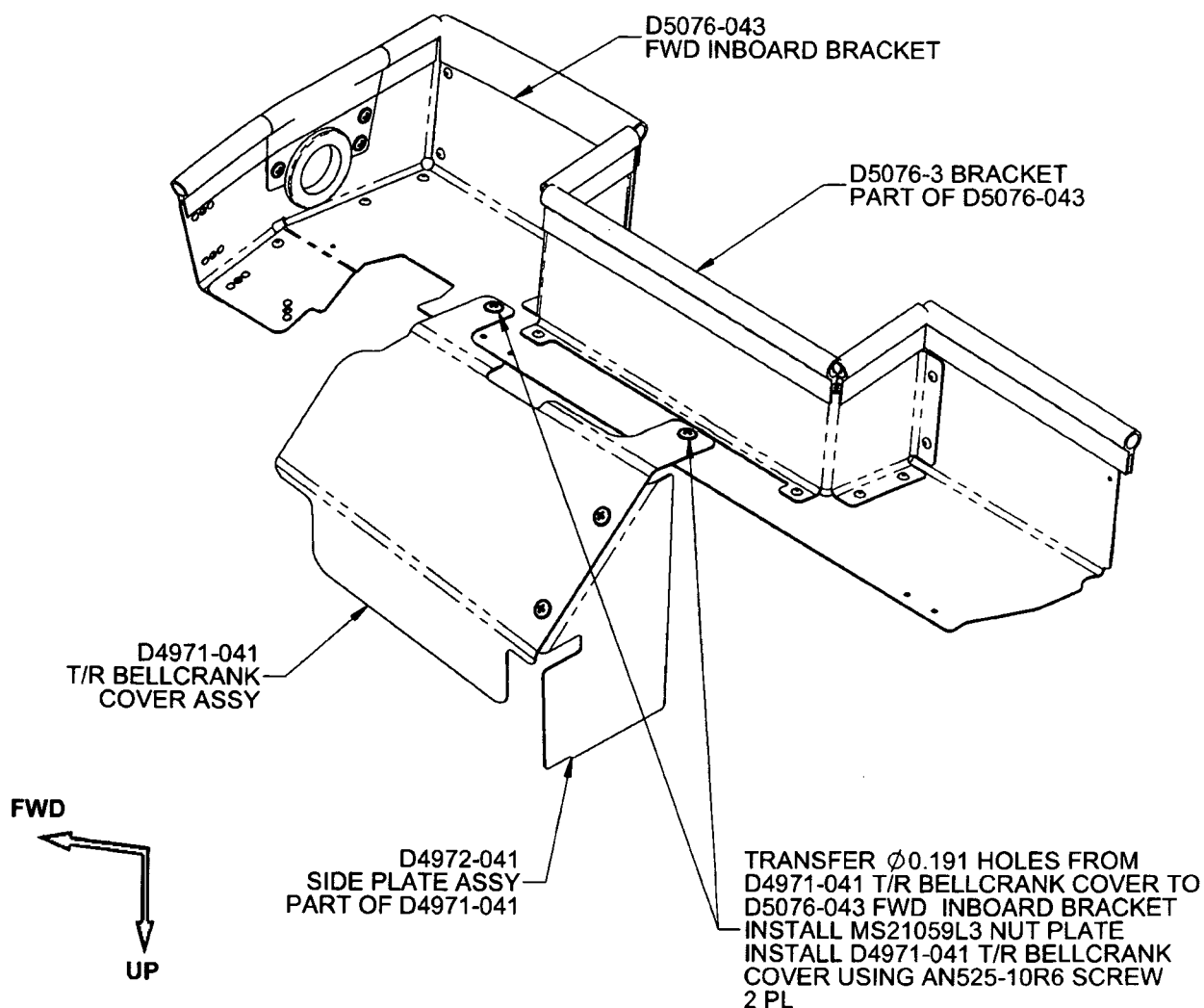
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <u>[Signature]</u> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 17 OF 19 |
| APPROVED | <u>[Signature]</u> | TITLE | SCALE |
| DE APPR. | <u>[Signature]</u> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



E **Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 18 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

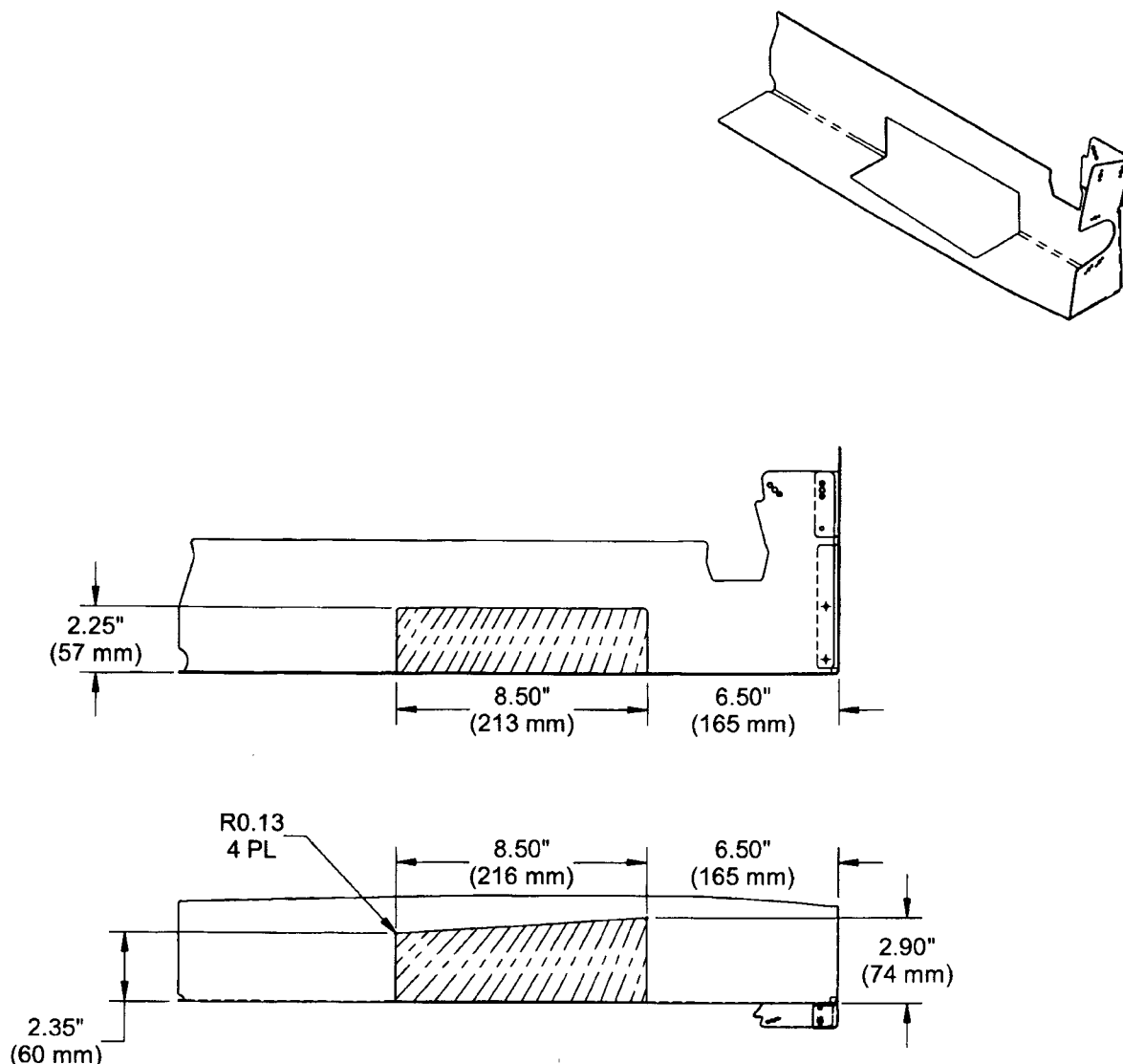


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 19 OF 19 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE | 14.03.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

2.0 Parts List

| Qty -141 | Qty -143 | Qty -145 | Part Number | Description |
|-------------|-------------|-------------|---------------|---|
| X | | | D350-567-141 | FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS) |
| | X | | D350-567-143 | FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS) |
| | | X | D350-567-145 | FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e) |
| 1 | 1 | 1 | D3802-1-024 | SEAL (24") |
| 1 | 1 | | D4434-041 | FWD-BRACKET ASSEMBLY |
| 1 | 1 | | D4434-047 | COVER ASSEMBLY |
| 1 | | | D4435-045 | T/R BELLCRANK COVER ASSEMBLY |
| 2 | 2 | 2 | D4435-9 | BRACKET |
| 1 | 1 | 1 | D4436-041 | AFT BRACKET ASSEMBLY |
| 1 | 1 | 1 | D4441-1-240 | RUBBER SEAL (24") |
| | | 1 | D4730-020-030 | VELCRO STRIP |
| | 1 | 1 | D4971-041 | T/R BELLCRANK COVER ASSEMBLY |
| | | 1 | D5076-041 | FWD BRACKET ASSEMBLY |
| 7 | 5 | 5 | AN3-3A | BOLT |
| 2 | 2 | 2 | AN525-10R6 | SCREW |
| 2 | 2 | 2 | AN525-832R7 | SCREW |
| | | 1 | CB 200 | 3.5g ACRYLIC ADHESIVE |
| 7 | 7 | 7 | MS21042L06 | NUT (OR MS21042-06) |
| 2 | 2 | 2 | MS21042L08 | NUT (OR MS21042-08) |
| 5 | 5 | 5 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | 2 | 2 | MS21059L3 | NUTPLATE |
| 7 | 7 | 7 | MS35206-229 | SCREW |
| 12 | 10 | 10 | NAS1149F0332P | WASHER (AN960-10L) |
| 14 | 14 | 14 | NAS1149FN616P | WASHER (OR AN960-6L) |
| 2 | 2 | 2 | NAS1149FN816P | WASHER (OR AN960-8L) |

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|--|-------------------|-------------------|-------------------------|-------------------|--------------------------|
| | | Arm | Moment | Arm | Moment |
| D350-567-141/-143/-145 Floor Window Close-out Kit | 3.9 lb 1.77 kg | 17.9 in 0.45 m | 69.8 in-lb 0.80 m-kG | 65.5 in 1.66 m | 255.5 in-lb 2.94 m-kG |

4.0 Installation Procedure


Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

| | | | |
|---------------|---|--|---------------|
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | DSI 9590 | SHEET 2 OF 19 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | FLOOR WINDOW CLOSE-OUT KIT | NTS |
| DATE 14.03.20 | | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |